1 5

**Quality Control** 

DQA:			_ Date:			<u> </u>							
						<b>WORK ORDER NON</b>	I-C	ONFO	RMANCE / UP	PDATE			AEROSPACE
QA Closed:		3	Date:		-					V	Vork Order u	odate only	
Work Orde	<b>3</b> r•					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Orde	٠.					Rework	٦		Skid-tube	Crosstube	¬ ·	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•	-				Use-as-is	1	1	noforming	Finishing	<del>-</del>	re/Packaging	<del></del>
NCR N	lo.					Suspected Unapproved	1		Large Fab	Composite	<u> </u>	Supplier	
							_	<u> </u>			<del></del>	· · · · · · · · · · · · · · · · · · ·	
Root					Desc	ription of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	n QC Inspector
Design													
Doc/Data	_												
Equip/Tooling	_												
Handling/Pre	_												
Material										•			
Operator													
Offset/Setup													
Process													
Supplier	-												
Training _	$\dashv$												
Transport	_												
Unapproved							EA	LUT CAT	TEGORY				
Landii	ng G			-	<del></del>	General	FA	OLI CA	IEGONI	-	· · · · · · · · · · · · · · · · · · ·		
Landi	_	Bending				Bend	Г	leolio/P	rogram	. Г	Outside Dim	ensions	Pressure/Forced
	_	Centre No	ot Concer	ntric		BOM/Route	$\vdash$	Grain	товгант	<u> </u>	Over/Under	- F	Set-up
	$\dashv$	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ì	Temperature/Cure
	-	Crimp/Kir	nk/Ripple.	/Wave	-	Burrs		4	ion Incomplete/Un	gualified	Part Lost/Mi		Weld
	$\neg$	Cuffs		,		Contamination		4	ions Incomplete/U	· •	Part Moved		Wrong Stock Pulled
	_	Crushing				Countersink		4	ned/off center	<u> </u>	Positioned V	ں Vrong	
	_	Heat Trea	it .			Cut Too Short		Mislabe			Power Loss/		Other
	-	Inspectio		Tube		Drawing		Misread		_	_		· · · · · · · · · · · · · · · · · · ·
		Marks/Ch				Drill Holes		Off-set					
		Turning S	equence			Finish		Out of 0	Calibration				
		Wave/Tw	ist in Tub	е		Fit/Function		Out of 9	Sequence				

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Memo

Packaging

Packaging

DQA:			Date:		<del></del>									TRACT		
QA Closed:		•	Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / UP		ork Order up	odate only		AEROSPACE		
		-				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde	er: _					ļ <u> </u>			الJ	_	¬					
0						Rework			Skid-tube	Crosstube	_	Water Jet	_	Engineering		
Part N	NO					Scrap			Machining	Small Fab	-1	d. Eng. Coor.	$\dashv$	Quality		
NCR N	۷o.	·				Use-as-is Suspected Unapproved		inerr	noforming Large Fab	Finishing Composite	Rec/Stol	re/Packaging Supplier		Other		
	<del></del>		1						1		T 6: 0					
Root		0-4-	Char	0.1	Desci	ription of work order update		nitial	Action		Sign &	\		061		
Cause	$\dashv$	Date	Step	Qty		or non-conformance	Cn	ief Eng	Descri	ption	Date	Verification	<u> </u>	QC Inspector		
Design																
Doc/Data	$\dashv$															
Equip/Tooling	$\dashv$															
Handling/Pre	H															
Material Operator	$\dashv$															
Offset/Setup	$\dashv$															
Process	$\dashv$															
Supplier												i				
Training	ᅥ															
Transport	$\neg$											i				
Unapproved			-													
							FAI	ULT CA	regory							
Landi	ng G	iear				General			· •	-	-					
•		Bending	٠			Bend		Folio/F	rogram		Outside Dim	ensions	╝	Pressure/Forced		
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	$\Box$	Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ાં _		Temperature/Cure		
		Crimp/Kir	nk/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	_	Weld		
		Cuffs				Contamination		4	tions Incomplete/U	nclear	Part Moved	Į		Wrong Stock Pulled		
		Crushing				Countersink	-	1	ned/off center		Positioned V					
	-	Heat Trea				Cut Too Short	-	Mislabe		L	Power Loss/	Surge		Other		
	_	Inspectio	-	Tube	<u></u>	Drawing	<del></del>	Misread				. ,				
	-	Marks/Ch			<u> </u>	Drill Holes	${f -}$	Off-set								
	_	Turning S				Finish	-	4	Calibration							
		Wave/Tw	ist in Tub	e		Fit/Function		Out of 9	Sequence							

Work Order ID 115775  April-04-14 10:21:27 AM				*115			Page 3					
Item ID: Revision ID: Item Name:	D3646-4 Arm			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*
	4/04/14 4/04/14	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						
Approvals:	Process QC:	Plan:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re		Reject Number,	Insp. Stamp
*160 *160*		QC21- Final Inspection	- Work Order Release	0.00						141	17/2	29

Quality Control

U14.07.22

DQA:		Date:				_		TRAC						
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / U		Wa	ork Order up	ndate only - F	$\neg$	AEROSPACE
					DISPOSITION						<del></del>			•
Work Orde	r:	= -			DISPOSITION				AGAINST	UE	PARTMENT,	PROCESS _		
				-	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	0				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR N	o				Suspected Unapproved	]		Large Fab	Composite			Supplier	_	
Root				Desci	ription of work order update		Initial	Act	ion		Sign &		T	
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Date	Verification		QC Inspector
Design														
Doc/Data														
quip/Tooling	_													
landling/Pre	_							•						
//aterial													١	
Operator														
Offset/Setup	_											•	-	
rocess														
upplier														
raining	_													
ransport			Ì								-		-	
Inapproved			<u> </u>	<u> </u>									$\perp$	
						FA	ULT CAT	EGORY						
Landin	_			_	General	_	1 .		r		!	r-	_	
	Bending			-	Bend	_	1 '	rogram			Outside Dim	· · · · · ·	┥	Pressure/Forced
_	Centre No	ot Concer	ntric	_	BOM/Route	<u> </u>	Grain				Over/Under	}-	_	Set-up
-	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa			_	Part Incorred			Temperature/Cure
-	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>	1	on Incomplete/Ur	· · · · · · · · · · · · · · · · · · ·		Part Lost/Mi	ssing	_	Weld
-	Cuffs				Contamination	_	4	ions Incomplete/U	Jnclear		Part Moved	Ĺ	\	Wrong Stock Pulled
	Crushing				Countersink		1 -	ned/off center			Positioned V		_	
1	Heat Trea			<u> </u>	Cut Too Short	_	Mislabe				Power Loss/	Surge		Other
<u> </u>	Inspection	•	Tube		Drawing '		Misread	İ						
-	Marks/Ch			<u> </u>	Drill Holes		Off-set							
	Turning S	•		<u> </u>	Finish		-i	Calibration						
· 1	Wave/Tw	ist in Tuk	e		Fit/Function		Out of 9	equence						

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**Picklist Print** 

April-04-14 10:21:27 AM

Work Order ID: 115775

D3646-4

Parent Item Name: Arm

\*115775\*

\*D3646-4\*

**Start Date:** 4/04/14

Required Date: 4/04/14

Page 1

Start Qty: 6.00

Required Qty: 6.00

**Comments:** 

Parent Item:

IPP revA 11.07.12 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	252.6141	3.1	19.57895		·	
*M304TR0 304 RD Tube .500 x .035W		035*							**		FF 1	4~07	7-17

Location	Loc Oty	Loc Code	~ . 00
MAT017 129108	252.6141		19.5709
125513	2.5998		
m126922	3		
m128084	127.0143		
m128495	120		

DQA:		_ Date:			-								TQAC
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UPDATE	\A/ <sub>4</sub>	ork Order u	adata only		AEROSPACE
QA Closea.		Date.	-			_	<del></del>		~ ~ ~	ork Order up	Juate Offig		
Work Order	:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
·	•				Rework			Skid-tube Crosstube	еГ	· .	Water Jet		Engineering
Part No	).				Scrap			Machining Small Fal	b┌	Pro	d. Eng. Coor.		Quality
					Use-as-is		Therr	noforming Finishin	g	Rec/Sto	re/Packaging		Other
NCR No	)				Suspected Unapproved			Large Fab Composite	e		Supplier		
		_					, ,			Ť	,	_	
Root				Desc	ription of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	n	QC Inspector
Design	4							·					
Doc/Data	_									:			•
Equip/Tooling													
Handling/Pre	-			•	•								
Material	-}											٠	
Operator Officet/Setup	-												
Offset/Setup Process	+										,		
Supplier	┪												•
Training	7							·					
Transport	1												
Unapproved													•
	•	<u> </u>				FA	ULT CAT	TEGORY					
Landing	Gear				General		_	· · · · · · · · · · · · · · · · · · ·					
	Bending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain		_	Over/Under	tolerance		Set-up
_	Cracks				Broken/Damage/Defect	_	Hardwa	are	_	Part Incorre	J	Ш	Temperature/Cure
	Crimp/Ki	nk/Ripple	/Wave	_	Burrs	<u> </u>	1 '	ion Incomplete/Unqualified	$\perp$	Part Lost/Mi	ssing		Weld
	Cuffs				Contamination	_	4	tions Incomplete/Unclear		Part Moved	į		Wrong Stock Pulled
	Crushing			<u> </u>	Countersink	_	4	gned/off center	-	Positioned V	-		
<u> </u>	Heat Trea			$\vdash$	Cut Too Short		Mislabe			Power Loss/	Surge		Other
	<b>⊣</b> `	n Strip in	Tube	<u> </u>	Drawing	<u> </u>	Misread						
\	Marks/Ch			<u> </u>	Drill Holes		Off-set						
		Sequence		<u> </u>	Finish	$\vdash$	4	Calibration					
[ ]	Wave/Tv	vist in Tub	e '		Fit/Function	1	Out of S	Sequence					

## DART AEROSPACE LTD



	_						TENOUT A
Description: /	7RM				Work O	rder: 115 /	/5
			Davi	<del>.                                      </del>	Part Num	her: D 364	-4
Inspection Drawing	: 🕽 30	646	Rev	·	7 87 6 7 6 7 7	10cm V 30 7 D	=7
		INI	CDEC	TION	SHEET		
	1	VII	JF LC	Incian	Mathod of Inspectio	n Comme	ents
Drawing Dimension		Actual Dimension	Accept	Keject	Method of Inspection		
26.50	0.030	27-50	V	<del> </del>	5 Fab - 0/7		
5,75	0.030	2,25	V	<del>                                     </del>	5 Fab-07		
2.25	0.030	45	1/	<b>-</b>	5 Fab - 06		•
45	+	15 °	V	1	SFab 06		
30°	1 7	30.	V		5 Fab -06		
30	•						
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Measured by:	7- 1	Checked By:		QC insi	ector: 97	Engineering Approv	al (if necessary
,	'		DAS	•	5-89		
14-	07-17		30 9-89		11/1/11	Date	. <sup>18</sup> 18 2
Date	•	Date [	7-08	Date	141/1/	Date	

